

Work Order ID 80216

80216

Page 1

February-14-12 4:16:30 PM

Item ID: D3371-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: *Alike* Stop ***NS2***
 Item Name: Pedal Lock Assembly
 Start Date: 14/02/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 28/02/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.L.T Date: 12/02/14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3371	Rev B								

120

0.00

120

Small Fab

Small Fab

Small Fab

Memo

0.00

- 1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
- 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
- 3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
- 4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	<u>M120369</u>

M120369

(2) *FF* 12-02-23

130

0.00

130

Small Fab

Small Fab

Small Fab

Memo

0.00

- Assemble lanyard to cyclic sock as per Dwg D3384
 Identify as D3384-045

(2) *FF* 12-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Small Fab	0.00							
140									
Small Fab	Memo	0.00							
Small Fab	1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371. 2- Identify as D3371-041 & attach keys 3- Record the Key Number on page 4								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>491</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									

② FF 12-02-23

W 12 . 02 . 24 ②

12/2/27 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MLJ 12/02/20

key

C 420A

MF
1202-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 80216

80216

Parent Item: D3371-041

D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 14/02/2012

Required Date: 28/02/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028		Purchased	No			120	Each	202.0000	2	4			

238-028

3/16" Dowel Pin .5" long

**

FF 12-02-23

Location

Loc Qty

Loc Code

ST400

202

106673

98

108114

77

17848

27

AN526C832R6

Purchased

No

120

Each

290.0000

4

8

AN526C832R6

Screw

**

FF 12-02-23

Location

Loc Qty

Loc Code

ST347

290

16612

290

D2728-7

Manufactured

No

120

Each

0.0000

0

0

D2728-7

Dart Logo label

**

FF 12-02-23

D3371-1

Manufactured

No

22554

120

Each

3.0000

1

2

D3371-1

Pedal Lock Base

**

FF 12-02-23

Location

Loc Qty

Loc Code

ST

-6

75200

2

ST485

1

70040

1

ST490

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

February-14-12 4:16:34 PM

Page 2

Work Order ID: 80216

80216

Parent Item: D3371-041

D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 14/02/2012

Required Date: 28/02/2012

Start Qty: 2.00

Required Qty: 2.00

D3371-3 Manufactured No

120 Each 2.0000 1 2

D3371-3

Pedal Lock Cover

**

FF 12-02-23

Location

Loc Qty

Loc Code

ST491

2

75201

2

D3373-7 Manufactured No

120 Each 0.0000 1 2

D3373-7

Cam Lock

D3385-3

Manufactured No

120 Each 86.0000 1 2

D3385-3

Hinge

**

FF 12-02-23

Location

Loc Qty

Loc Code

ST041

86

22387

86

CBL-1240 Purchased No

130 f 721.7418 1.6666

CBL-1240

Cable

**

FF 12-02-23

Location

Loc Qty

Loc Code

GA

721.741789

113565

3.911789

119021

477.922

119690

239.908

3.5086

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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February-14-12 4:16:34 PM

Page 3

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Parent Item: D3371-041

D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 14/02/2012

Required Date: 28/02/2012

Start Qty: 2.00

Required Qty: 2.00

CBL-460 Purchased No

130 Each 413.0000 2 4

CBL-460

Loop Sleeve

**

FF 12-02-23

Location

Loc Qty

Loc Code

GA

413

117947

4

118140

33

119021

188

119690

188

D3384-1 Manufactured No

130 Each 3.0000 1 2

D3384-1

Cyclic Sock

**

FF 12-02-23

Location

Loc Qty

Loc Code

ST486

3

77012

3

AN960-416 NAS1149F0463P Purchased No

140 Each 0.0000 2 4

AN960-416

Washer

HX-81

Purchased No

140 Each 51.0000 1 2

HX-81

1/4"-20 SHCS 3/8" long

**

FF 12-02-23

**

FF 12-02-23

Location

Loc Qty

Loc Code

ST

50

120357

50

ST390

1

114383

1

~~120773~~

120773

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

STANDARD
RELEASE
FROM

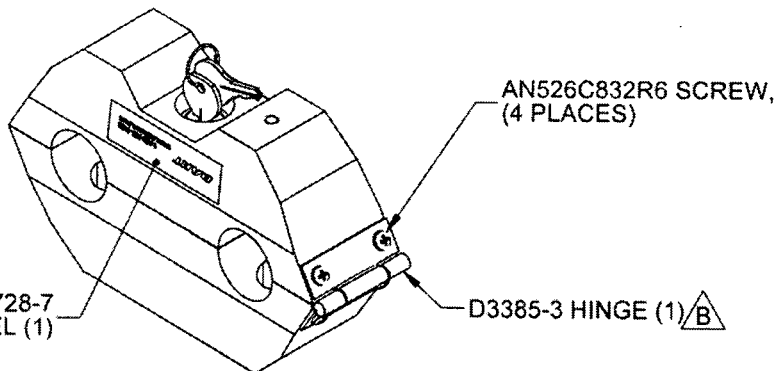
UNCONTROLLED

SUBMIT

W. J. J.

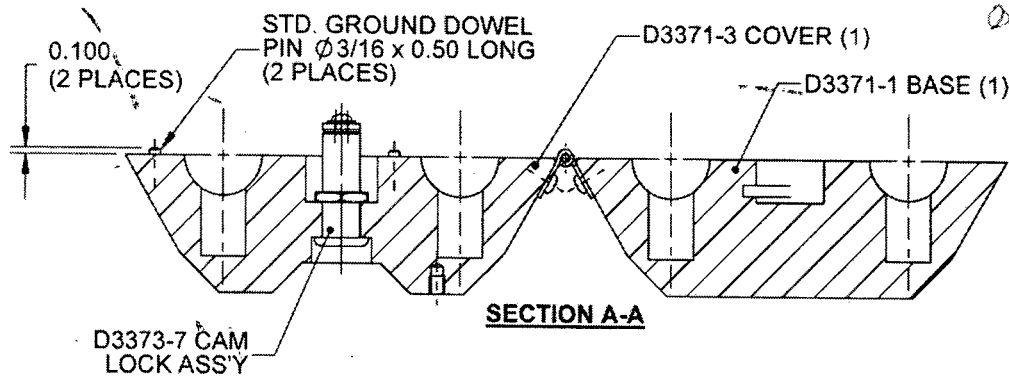
NO. 80214 M.C.J

12/02/14 D2728-7
LABEL (1)

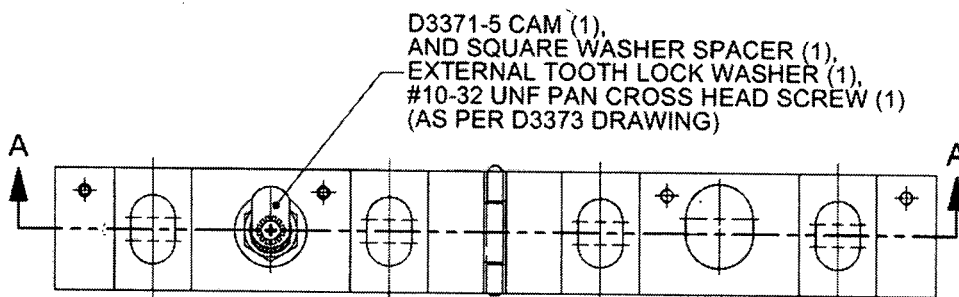


PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



SECTION A-A



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

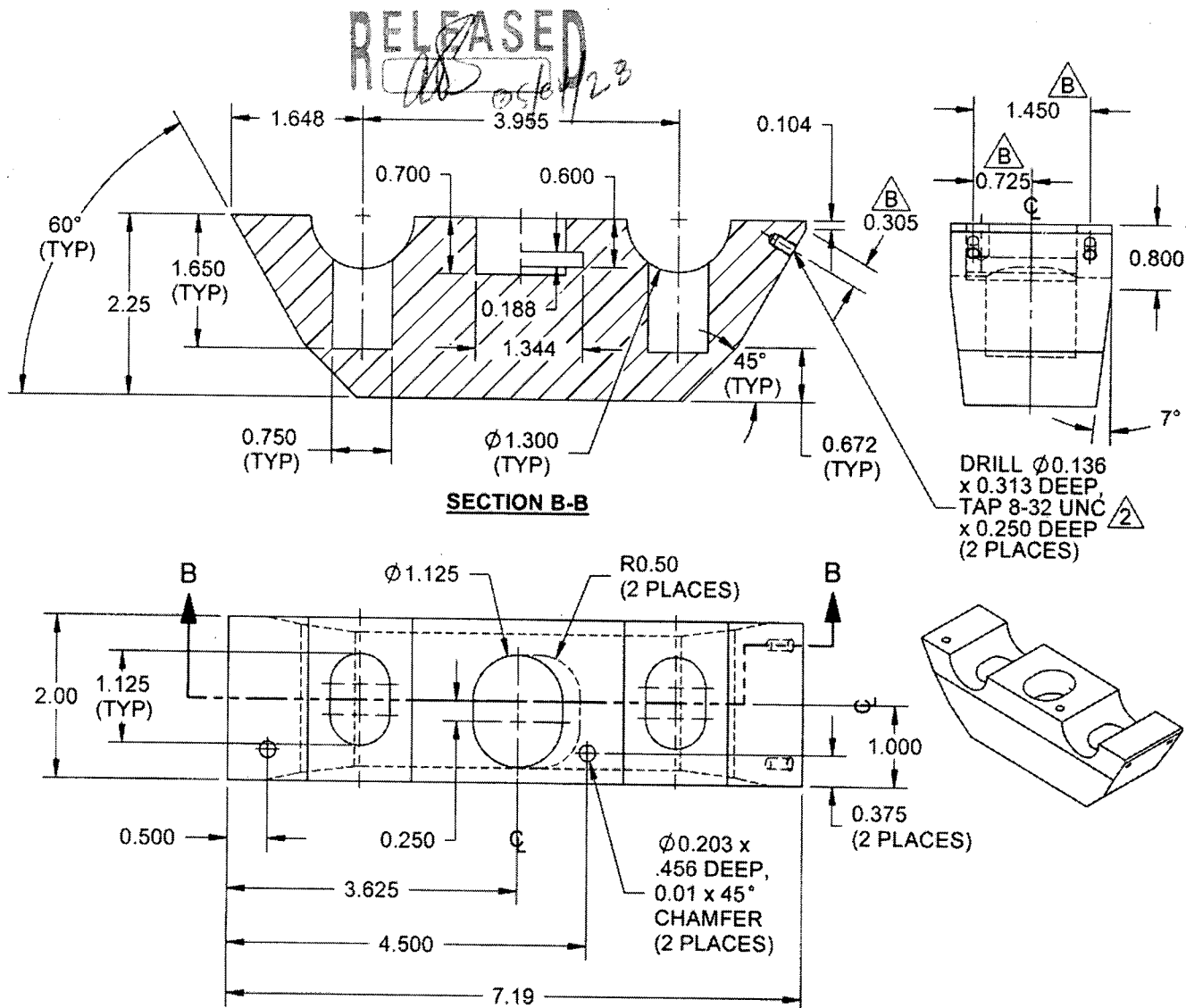
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 43	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED R	APPROVED [Signature]	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



D3371-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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60212

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

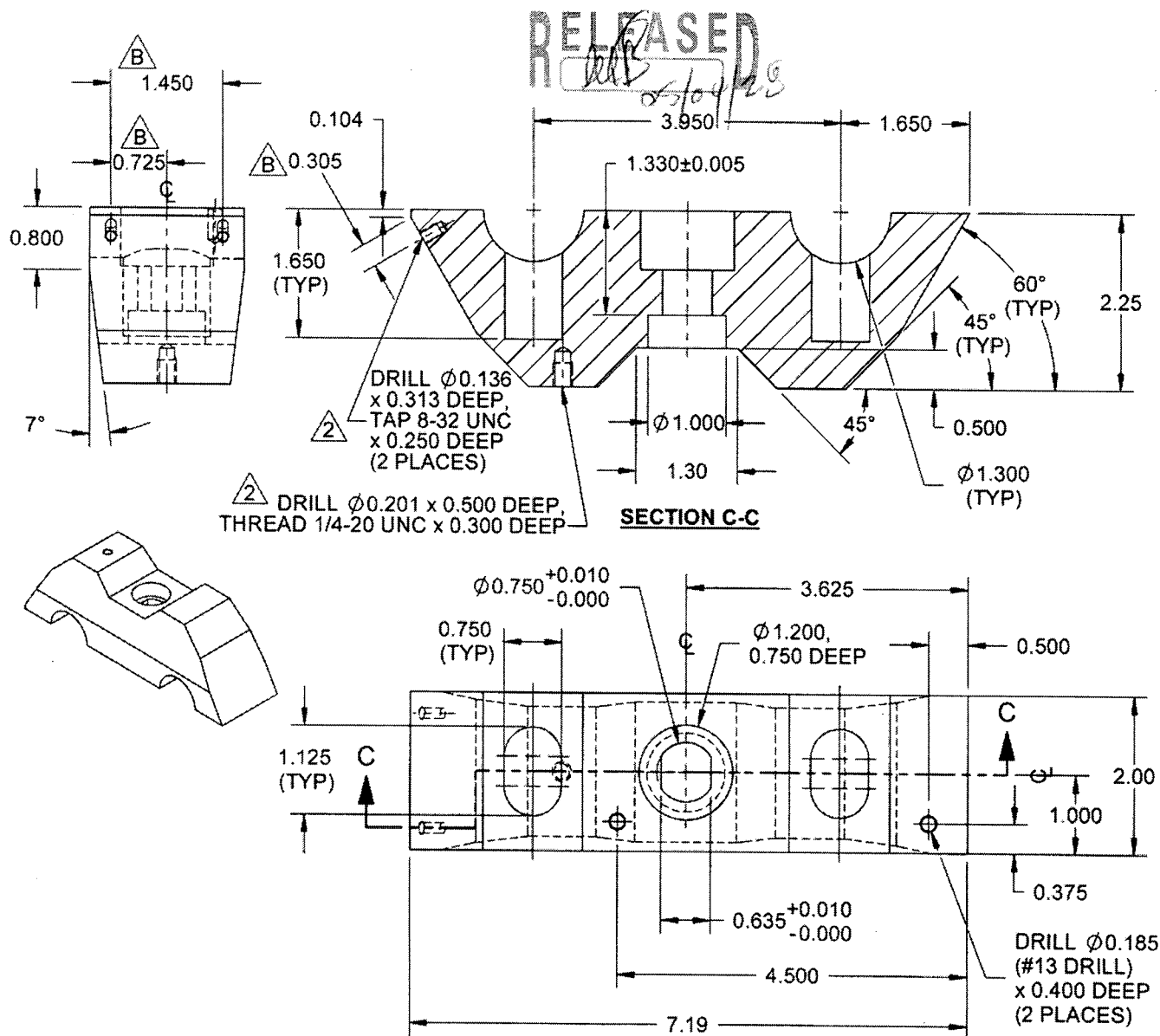
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



D3371-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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2021/2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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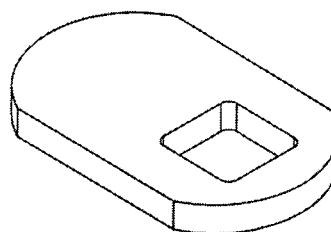
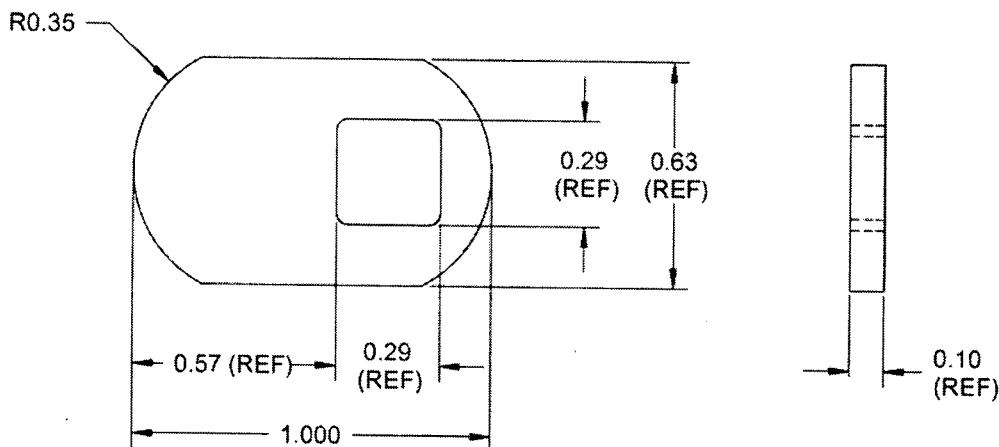
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B
DATE 05.03.22		TITLE PEDAL LOCK	SHEET 4 OF 4
			SCALE 2:1

RELEASED
[Signature]
05/04/28

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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80214

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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